

**Work Order ID 59082**

May 26, 2010 9:06:08 AM



Page 1

Item ID: D3913-041

Accept



Setup Start



Revision ID:

Item Name: Long Basket Base Assembly, 350

Stop



Start Date: 5/26/10 Start Qty: 1.00



Cust Item ID:

Required Date: 6/03/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3913	A

100 Weld per dwg A/R S.S. rod Batch: 1113328 0.00  
 Large Fab

Large Fab  
 Memo 0.00  
 1- assemble ribs , weld as per dwg D3913\*using DT9610A  
 \*\*\*inspect before welding mesh\*\*\*  
 2- tack weld mesh on basket as per dwg D3913 and trim mesh to fit  
 3- weld hinge (3) and Mounting brackets as per dwg D3913  
 \*\*\*take lid to locate hinge and bracket\*\*\*

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00  
 QC

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 59082**

Page 2

May 26, 2010 9:06:08 AM

Item ID: D3913-041

Accept



Setup Start



Revision ID:

Item Name: Long Basket Base Assembly, 350

Stop



Start Date: 5/26/10 Start Qty: 1.00



Cust Item ID:

Required Date: 6/03/10 Req'd Qty: 1.00



Customer:

**Reference:**

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

120



QC

Quality Control

Operation  
Description

QC5- Inspect part completeness to step on W/O

Set Up/  
Run Hours

0.00

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130



Powdercoat

Powder Coating

\*NO COAT WAS APPLIED

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00

=&gt; N 10/06/03

0.00

Memo

0.00

✓ 1- Plug holes and mask only interior of hinge (3) prior to powder coat

M11-207

1ST COAT:

START TIME: 12:00 PM

OVEN TEMPERATURE: 400° F

FINISH TIME: 12:30 PM

\*\*\*\*\* 2nd coat if necessary \*\*\*\*\*

2ND COAT:

START TIME: 12:45 PM

OVEN TEMPERATURE: 400° F

FINISH TIME: 1:15 PM

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

Page 1

May 26, 2010 9:06:04 AM

**Work Order ID:** 59082



**Parent Item:** D3913-041



**Parent Item Name:** Long Basket Base Assembly, 350

**Start Date:** 5/26/10

**Required Date:** 6/03/10

**Comments:** IPP Rev:A new issue DD 10.03.19 verified by:EC  
chg qty's DD 10.04.12 verified by:EC

IPP Rev:B

**Start Qty:** 1.00

**Required Qty:** 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2581 		Manufactured	No			100	Each	34.0000	2	2		SS 10/06/01	

Mounting Bracket

## Location      Loc Qty      Loc Code

WA	34	
46086	2	
51745	2	
57185	1	
58301	9	
58687	20	

D3913-1

Manufactured No

100 Each 0.0000

1

① SS 10/06/01

Rib

D3913-15

Manufactured No

100 Each 10.0000

1

SS 10/06/01

Wide Handle Plate

## Location      Loc Qty      Loc Code

WA	10	
58125	7	
58586	3	

D3913-3

Manufactured No

100 Each 1.0000

1

① SS 10/06/01

Rib

D3913-7

Manufactured No

100 Each 0.0000

2

② SS 10/06/01

Rib

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

May 26, 2010 9:06:04 AM

Page 2

Work Order ID: 59082



Parent Item: D3913-041



Parent Item Name: Long Basket Base Assembly, 350

Start Date: 5/26/10

Required Date: 6/03/10

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC  
chg qty's DD 10.04.12 verified by:EC

IPP Rev:B

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3913-9		Manufactured	No			100	Each	1.0000	1	1		10/06/01	

Hinge Rib

Location      Loc Qty      Loc Code

WA                  1  
58582              1

D3916-041



Manufactured No

100 Each 0.0000



2

1

10/06/01

Rib Assembly



Manufactured No

100 Each 2.0000



3

3

10/06/01

D3916-5



Manufactured No

100 Each 2.0000



3

3

10/06/01

Light Rib



Location      Loc Qty      Loc Code

WA                  2  
57023              2

D4016-1



Manufactured No

100 Each 6.0000



3

3

10/06/01

Hinge Half, Base



Location      Loc Qty      Loc Code

WA                  6  
58657              6

D4017-7



Manufactured No

100 Each 3.0000



1

3

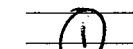
10/06/01

Rib



Location      Loc Qty      Loc Code

WA                  3  
58133              1  
58521              2



1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

May 26, 2010 9:06:05 AM

Page 3

**Work Order ID:** 59082



**Parent Item:** D3913-041



**Parent Item Name:** Long Basket Base Assemby, 350

**Start Date:** 5/26/10

**Required Date:** 6/03/10

**Comments:** IPP Rev:A new issue DD 10.03.19 verified by:EC  
chg qty's DD 10.04.12 verified by:EC

IPP Rev:B

**Start Qty:** 1.00

**Required Qty:** 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item Manufactured	Primary Location No	Last Location	Route Seq ID 100	Unit of Measure Each	Qty on Hand 0.0000	Qty per Kit 2	Total Qty 2	Qty Issued	Date Issued	Status
D4017-9													
Rib													
D4020-1			Manufactured	No		100	Each	0.0000	1	1			
Mesh (350 Basket Long, Base)													
D4020-11			Manufactured	No		100	Each	4.0000	2	2			
End Mesh, Basket													
					<u>Location</u>		<u>Loc Qty</u>			<u>Loc Code</u>			
					WA		4						
					56990		1						
					58136		3						
D4021-1			Manufactured	No		100	Each	16.0000	3	3			
Handle Plate													

	<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
	ST109	5	
	57086	5	
	WA	11	
	58525	2	
	58746	9	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

Page 4

May 26, 2010 9:06:06 AM

Work Order ID: 59082



Parent Item: D3913-041



Parent Item Name: Long Basket Base Assembly, 350

Start Date: 5/26/10

Required Date: 6/03/10

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC  
chg qty's DD 10.04.12 verified by:EC

IPP Rev:B

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4034-041		Manufactured	No			100	Each	5.0000	1	1		SM 10/06/01	

Aft Upper Rib Assembly

Location	Loc Qty	Loc Code
----------	---------	----------

WA	5	
58141	2	
58696	3	

D4034-043

Manufactured No

100 Each 3.0000

1

(1)

SM 10/06/01

Fwd Upper Rib Assembly

Location	Loc Qty	Loc Code
----------	---------	----------

WA	3	
58697	3	

AN3-10A

Purchased No

150 Each 60.0000

6

(1)

EP 10/06/03

Bolt

Location	Loc Qty	Loc Code
----------	---------	----------

ST351	60	
114330	60	

AN960JD8

NAS1149DN832 Purchased J

150 Each 0.0000

2

6

EP 10/06/03

Washer Q57017

NAS1149DN832 J M114740 (2x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

## Picklist Print

May 26, 2010 9:06:06 AM

Page 5

Work Order ID: 59082



**Parent Item:** D3913-041



**Parent Item Name:** Long Basket Base Assembly, 350

Start Date: 5/26/10

**Required Date:** 6/03/10

**Comments:** IPP Rev:A new issue DD 10.03.19 verified by:EC  
chg qty's DD 10.04.12 verified by:EC

IPP Rev:B

**Start Qty:** 1,00

**Required Qty:** 1.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

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May 26, 2010 9:06:07 AM

Work Order ID: 59082



Parent Item: D3913-041



Parent Item Name: Long Basket Base Assemby, 350

Start Date: 5/26/10

Required Date: 6/03/10

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC  
chg qty's DD 10.04.12 verified by:EC

IPP Rev:B

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
NAS1149F0332P		Purchased	No			150	Each	811.0000	12	12		E5/10/06/03	

WASHER

Location	Loc Qty	Loc Code
ST275	811	
18057	811	12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

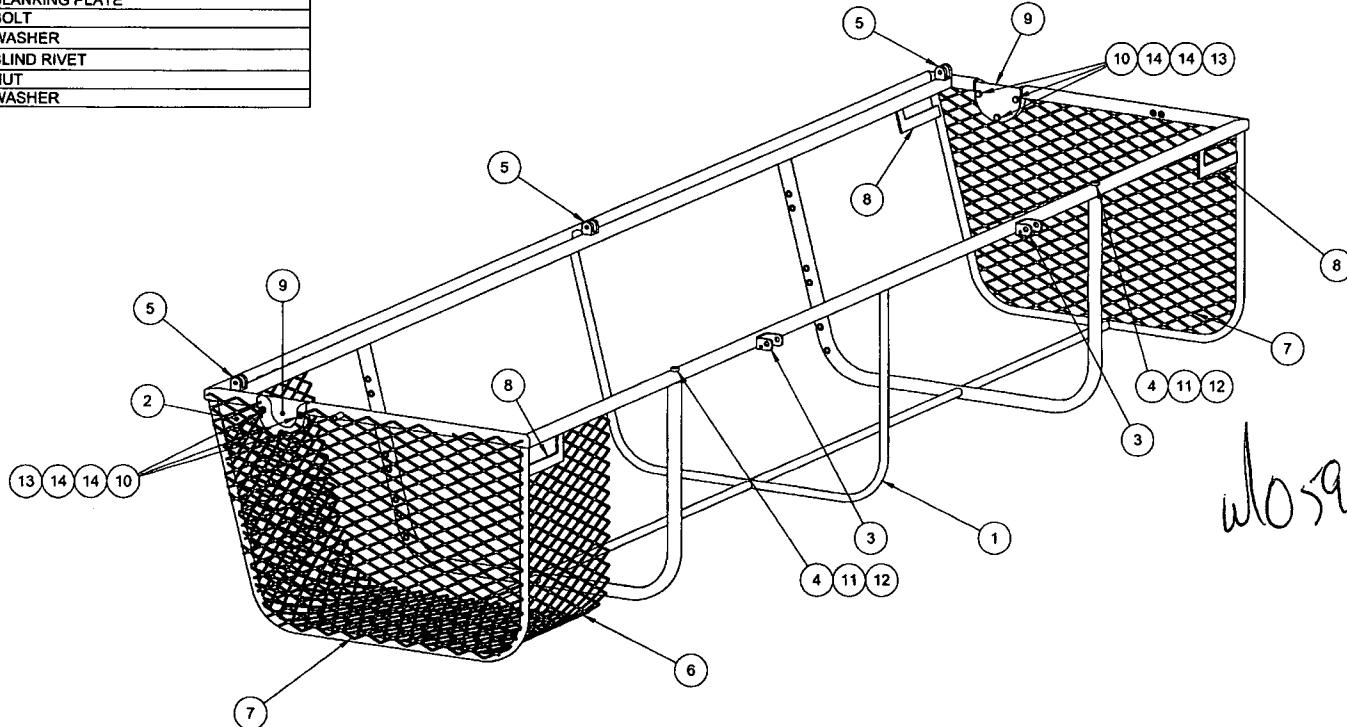
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY	P/N	DESCRIPTION
	X	D3913-041	LONG BASKET BASE ASSY (350)
1	1	D3913-101	TUBULAR ASSY (350 SHORT BASKET)
2	1	D3913-15	WIDE HANDLE PLATE
3	2	D2581	MOUNTING BRACKET
4	2	D2931	BUMPER
5	3	D4016-1	HINGE HALF, BASE
6	1	D4020-1	MESH (350 BASKET LONG BASE)
7	2	D4020-11	END MESH, BASKET
8	3	D4021-1	HANDLE PLATE
9	2	D4021-5	BLANKING PLATE
10	6	AN3-10A	BOLT
11	2	AN960JD8	WASHER
12	2	MS20600AD4W3	BLIND RIVET
13	6	MS21042L3	NUT
14	12	NAS1149F0332P	WASHER

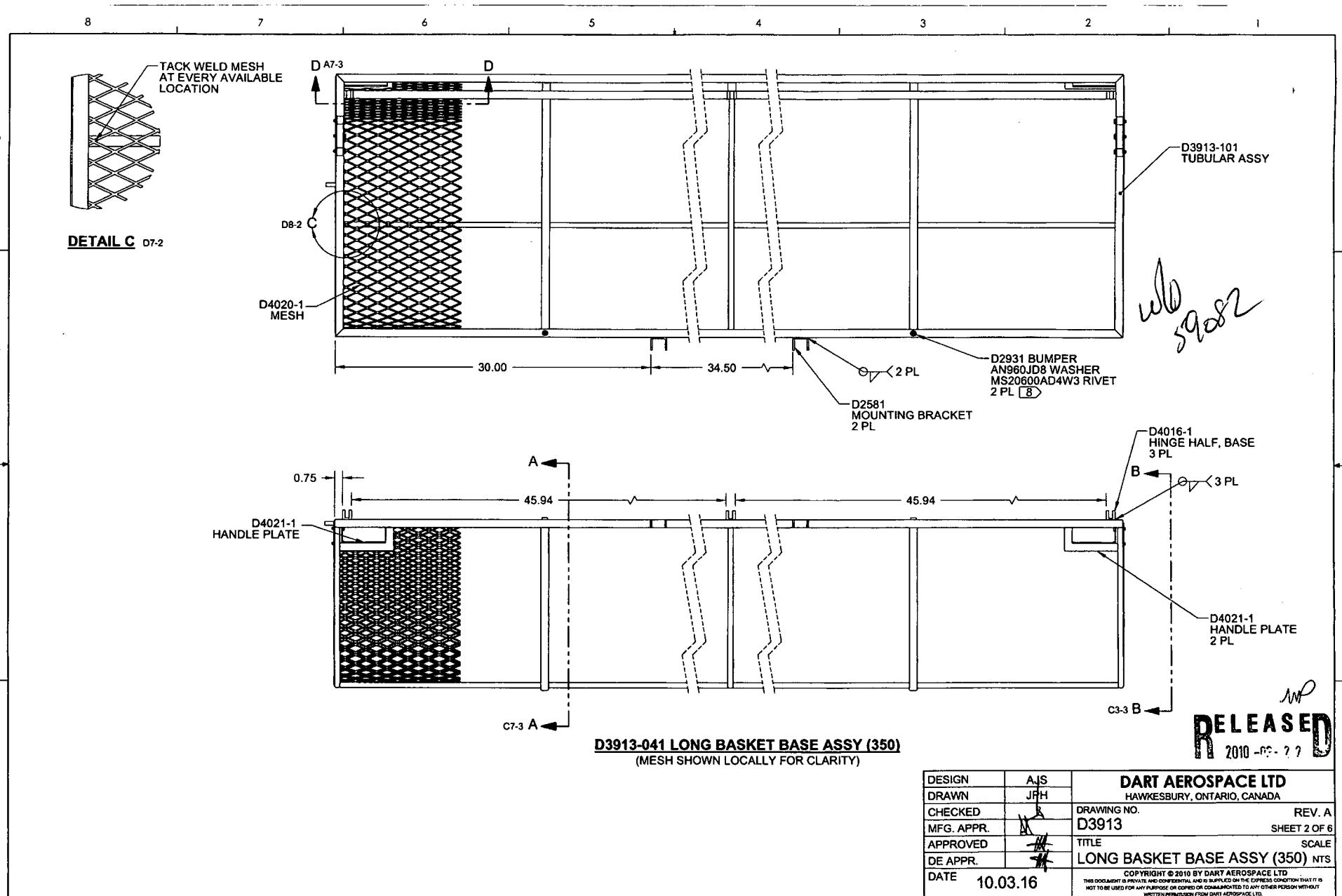


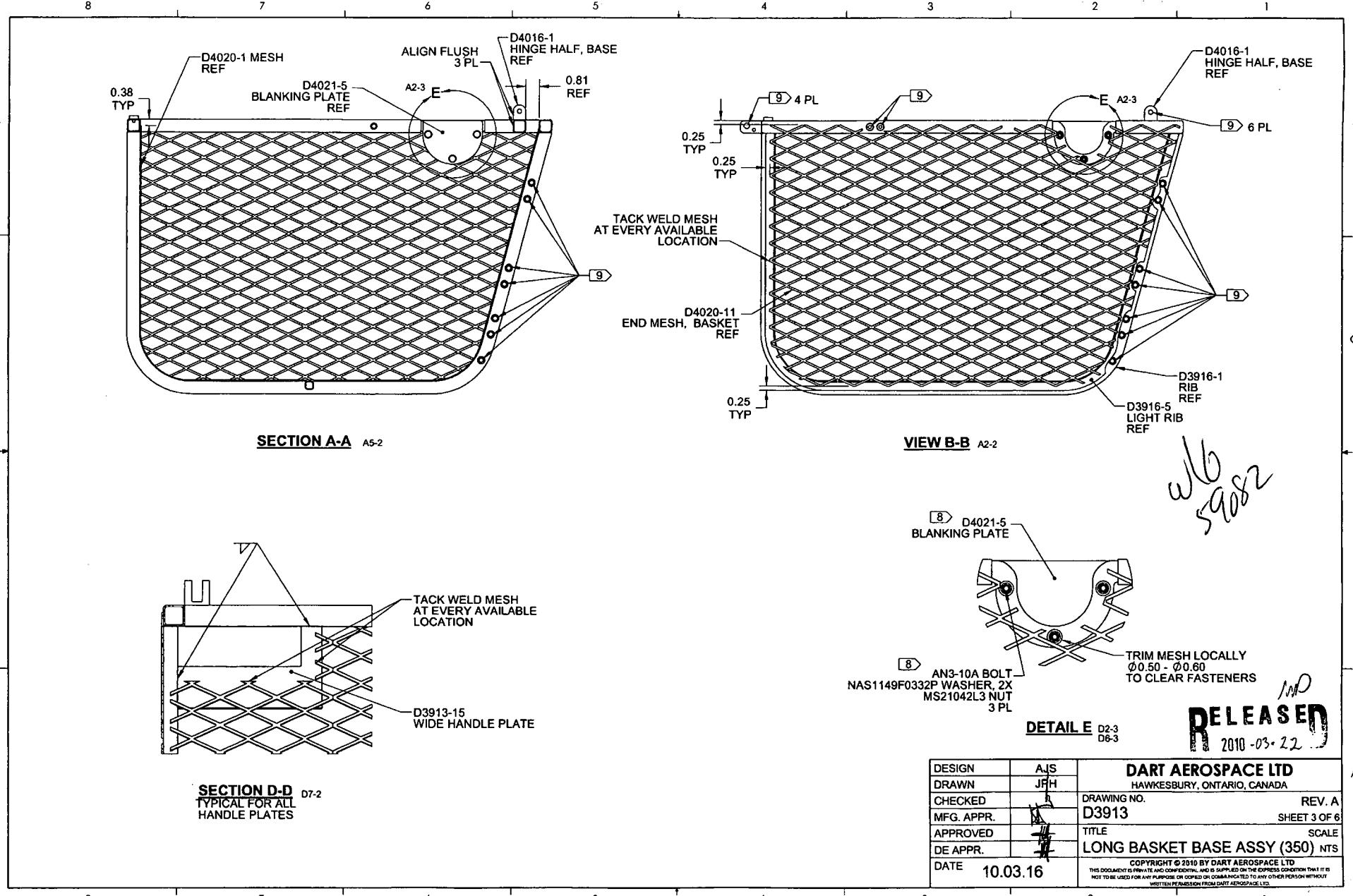
**D3913-041 LONG BASKET BASE ASSY (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

- NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: N/A
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: 43.3 lbs APPROX
  - 8) INSTALL AFTER FINISH
  - 9) MASK HOLES PRIOR TO POWDER COAT
  - 10) WELD PER DART QSI 004

RELEASED  
2010-03-22  
JPH

A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 1 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350) NTS	
DATE	10.03.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	





DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	JFH	
CHECKED		
MFG. APPR.		
APPROVED		
DE APPR.		
DATE	10.03.16	

8 7 6 5 4 3 2 1

ITEM	QTY	P/N	DESCRIPTION
	-101	X D3913-101	TUBULAR ASSY (350 LONG BASKET)
1	1	D3913-1	RIB
2	1	D3913-3	RIB
3	2	D3913-7	RIB
4	1	D3913-9	HINGE RIB
5	3	D3916-5	LIGHT RIB
6	2	D3916-041	RIB ASSY
7	1	D4017-7	RIB
8	2	D4017-9	RIB
9	1	D4034-041	AFT UPPER RIB ASSY
10	1	D4034-043	FWD UPPER RIB ASSY

D

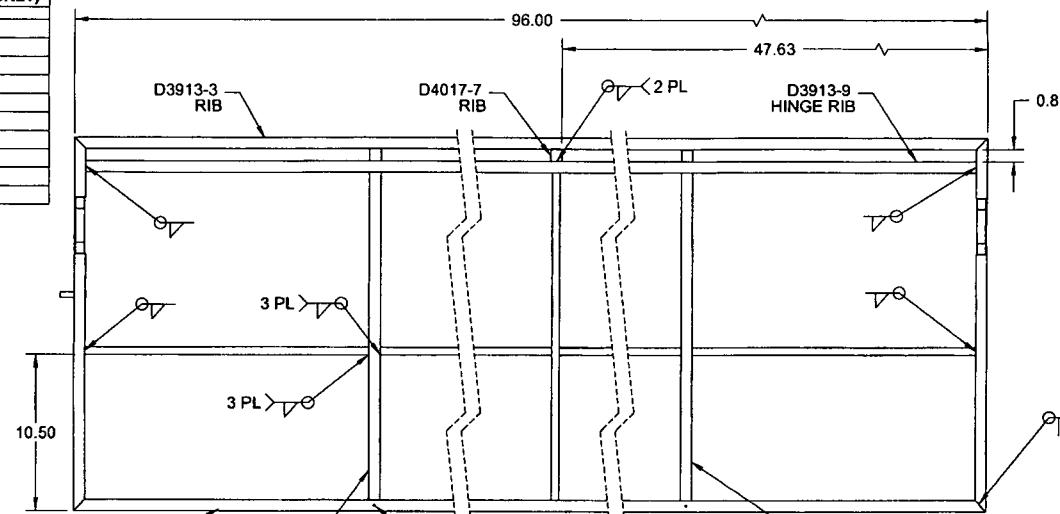
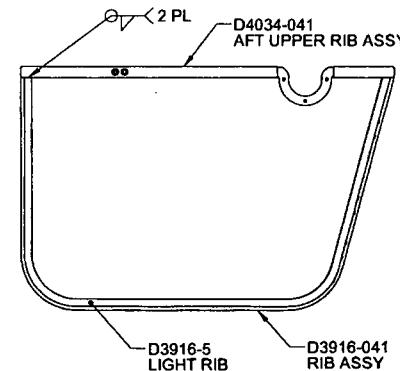
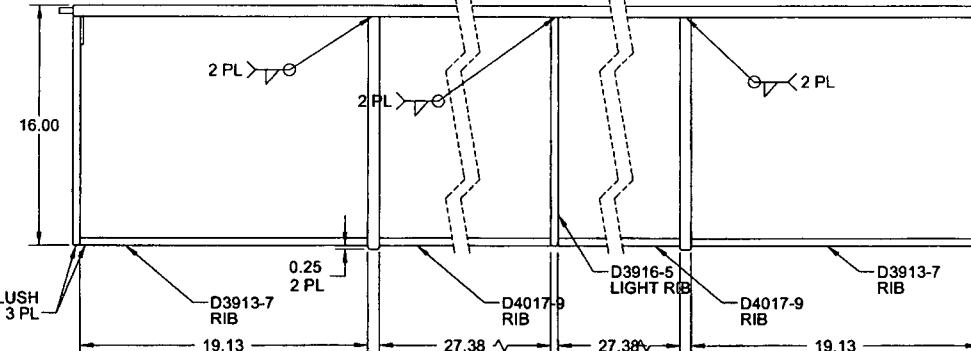
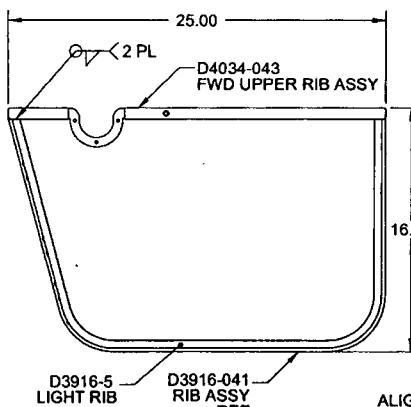
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C

C

B

B

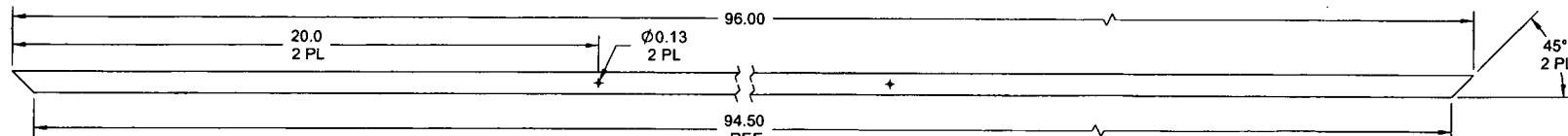
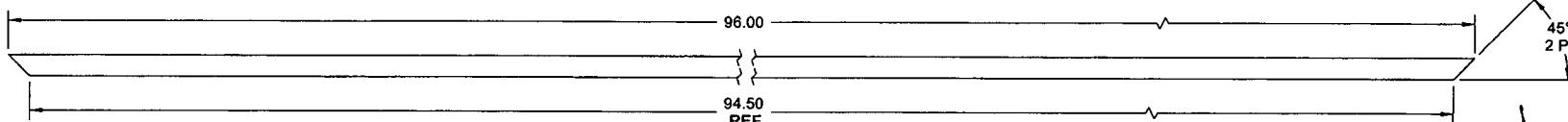
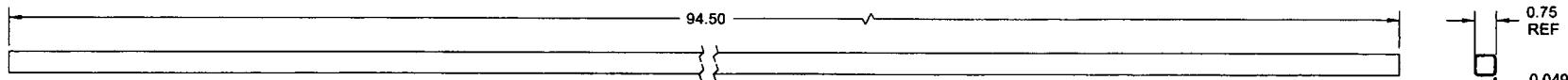


RELEASED  
2010-03-27  
NP

- NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 22.53 lbs
  - 8) TOLERANCE FOR XX.XX DIMENSIONS  $\pm 0.06$  FOR D3913-101
  - 9) WELD PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JFH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SL	DRAWING NO.	
MFG. APPR.	SL	REV. A	
APPROVED	SL	D3913	
DE APPR.	SL	SHEET 4 OF 6	
DATE	10.03.16	TITLE	
		SCALE	
		LONG BASKET BASE ASSY (350) NTS	
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8 7 6 5 4 3 2 1

D3913-1 RIBD3913-3 RIBD3913-7 RIBD3913-9 HINGE RIB

## NOTES:

1) MATERIAL -1, -3, -9: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL  
REF DART SPEC. M304TS0.750W.049

-7: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL  
REF DART SPEC. M304TS0.500W.049

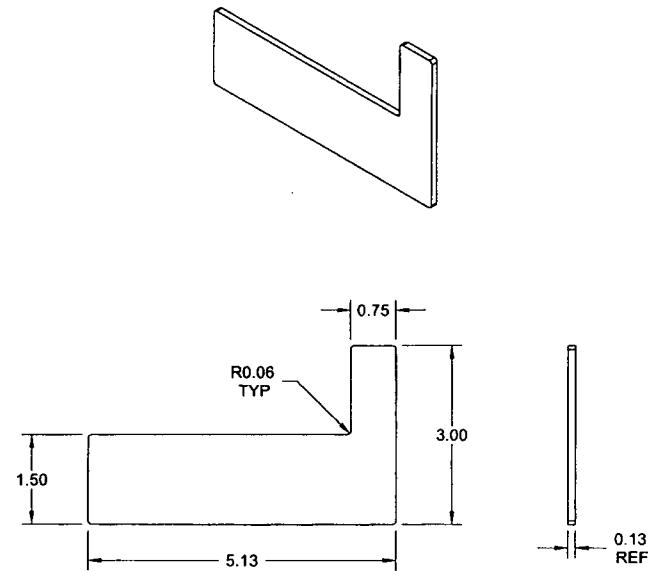
- 2) FINISH: NONE  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
6) IDENTIFICATION: N/A  
7) WEIGHT: SEE ASSEMBLED WEIGHTS

8 7 6 5 4 3 2 1

**RELEASED**  
2010-03-22  
*AN*

DESIGN	AJS	DART AEROSPACE LTD
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>M</i>	DRAWING NO.
MFG. APPR.	<i>M</i>	REV. A
APPROVED	<i>M</i>	D3913
DE APPR.	<i>M</i>	SHEET 5 OF 6
DATE	10.03.16	TITLE
		SCALE
		LONG BASKET BASE ASSY (350) NTS

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WRITTEN PERMISSION FROM DART AEROSPACE LTD.



**D3913-15 WIDE HANDLE PLATE**

**NOTES:**

- 1) MATERIAL: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH,  
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240  
REF DART SPEC M304S11GA
- 2) FINISH : NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.31 lbs

DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	JRH	HAWKSBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	
MFG. APPR.		D3913	REV. A
APPROVED		SHEET 6 OF 6	
DE APPR.		TITLE	SCALE
DATE	10.03.16	<b>LONG BASKET BASE ASSY (350) NTS</b>	

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2010-03-22  
*[Handwritten signature]*